

**Work Order ID 55090**

Page 1

January 5, 2010 3:16:31 PM

Item ID: D3823-2KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Overhead Rear, RH-Grey

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*10-1-05*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

*BB*  
*10/01/27*  
*(XI)*

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA031 using tool DT9113  
Dwg Rev: *C*  
Folio Rev: *A-B*

*BB*  
*01/01/27*  
*(XI)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Process Plan:

Date:

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Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Visually inspect part for proper formation and texture	0.00							
130 	QC8- Inspect parts - second check.	0.00							
QC Quality Control	Memo	0.00							
140 		0.00							
HandThermo Hand Finishing Thermoforming	Memo 1-Trim to finished dimensions as per Dwg	0.00							

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Revision ID:

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Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

MC 10/01/28  
(X1)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=&gt; S 10/01/28

EC

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

10-1-28

10/01/28

W/O:		WORK ORDER CHANGES					
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Page 4

January 5, 2010 3:16:31 PM

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Revision ID:

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Item Name: Overhead Rear, RH-Grey

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/29 JG  
cmf 10-1-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Page 1

January 5, 2010 3:16:36 PM

Work Order ID: 55090



Parent Item: D3823-2KGY



Parent Item Name: Overhead Rear, RH-Grey

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased		No			sf	519.7508	11.1556			



Kydex steel grey

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111807

519.7508

519.7508

St. 10/01/27.  
XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 35090
<b>Description:</b> Rear Overhead, RH		<b>Part Number:</b> D3823-2KIV/KGY
<b>Inspection Dwg:</b> D3823	<b>Rev:</b> C	<b>Page</b> 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

**Measured by:** *Wk* **Date:** 10/01/27

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.641"	✓			
0.44	Min	0.568"	✓			
1.75	Min	1.884"	✓			
0.045	Min	0.060"	✓			
0.055	Min	0.067"	✓			

**Measured by:** *Wk* **Date:** 10/01/28

**Audited by:** *BB* **Date:** 10/01/28

**Prototype Approval:** N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

C	ADD STEEL GRAY COLOUR OPTION. ADD IVORY P/M'S D3823-1/2-2/3(KIV) AND ADD STEEL GRAY P/M'S G3823-1/2-2/3(KGY) (ZN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1/2-2/3 FOR BETTER FIT WITH D3824-1/3 HAT BIN (ZN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (ZN B7-1, D7-2); 0.45 WAS 0.26 (ZN B8-3)	PH	09.02.06
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 0
MFG. APPR.		D3823	SHEET 1 OF 1
APPROVED		TITLE	SCAL
DE APPR.		REAR OVERHEAD	NT
DATE	09.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS LOANED TO YOU BY DART AEROSPACE LTD. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

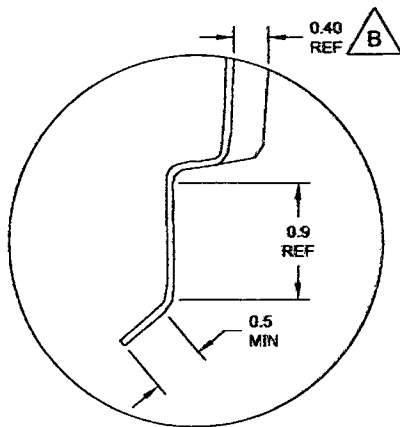
W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

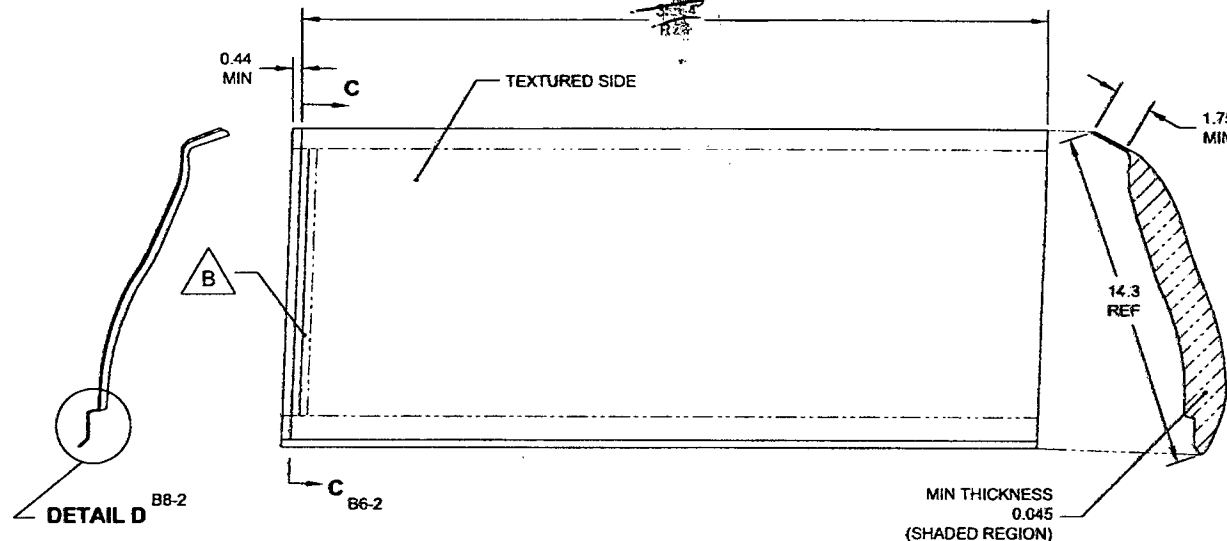
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**DETAIL D**  
SCALE 5X

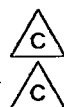
**SECTION C-C**



**D3823-2 REAR OVERHEAD, RH**

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3823-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	W10 35090	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RS	DRAWING NO. D3823
CHECKED	RS	REV. C
MFG. APPR.	RS	SHEET 2 OF 3
APPROVED	RS	TITLE REAR OVERHEAD
DE APPR.	RS	SCALE NTS
DATE	09.05.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
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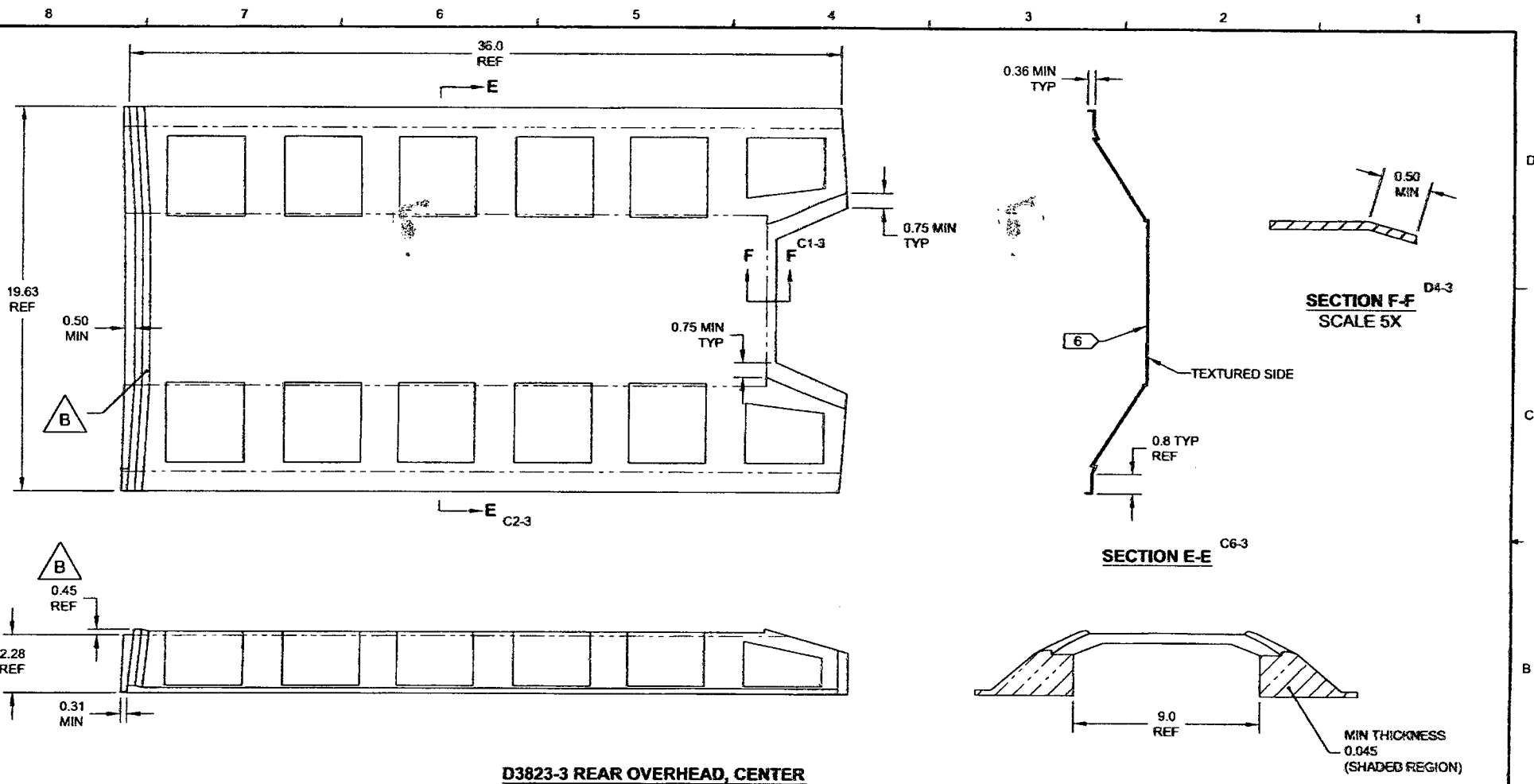
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DTS110 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

C  
C

PART NUMBER	DESCRIPTION
D3823-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 3 OF 3 SCALE NTS
DRAWN	PH		
CHECKED			
MFG. APPR.	DJO		
APPROVED	AW		
DE APPR.		TITLE	REAR OVERHEAD
DATE	09.05.05	<small> COPYRIGHT © 2004 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

RELEASED  
09/05/05

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